

**DEPARTMENT OF TRANSPORTATION****DIVISION OF ENGINEERING SERVICES**

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch  
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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:**Pursell, Gary**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-012047**Date Inspected:** 15-Jan-2010**Project Name:** SAS Superstructure**OSM Arrival Time:** 700**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1700**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai**CWI Name:** ZPMC and ABF**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** Tower**Summary of Items Observed:**

On this date Caltrans OSM Quality Assurance (QA) Inspector Mr. Wai Pau, was present during the times noted above for observations relative to the work being performed.

**Bay 11**

East tower lift #5:- Caltrans QA Inspector observed four welders performed SMAW process on inner corner longitudinal seam welds that connected skin plate C to D and D to E. The seam welds number #ESD1-TL5-2B/F-16A/39A and ESD1-TL5-2B/F-24B/40A. The SMAW welding was monitored and recorded by ZPMC and ABF QC inspector. Based on Caltrans QA inspector observations, no discrepancies were noted.

East tower lift #5:- Caltrans QA Inspector observed two welding operators performed SAW process on exterior corner longitudinal seam welds that connected skin plate B to C. The seam welds number

#ESD1-TL5-2B/F-11A/38A. The SAW welding was monitored and recorded by ZPMC and ABF QC inspector.

Based on Caltrans QA inspector observations, no discrepancies were noted.

Tower strut connection plate: - Caltrans QA Inspector observed a ZPMC welding operator performed SAW process on CJP weld of tower strut connection plate for tower elevation 123m. . The CJP weld and plate ID are ED1-STSA4-6-131M-2-7B, ND1-STSA4-6-132M-2-7B, ND1-STSA4-6-131M-1-7B, ED1-STSA4-6-135M-1-7A, ED1-STSA4-6-135M-2-7A and ND1-STSA4-6-135M-1-7A. The SAW welding was monitored and recorded by ZPMC and ABF QC inspector. Based on Caltrans QA inspector observations, no discrepancies were noted.

West tower lift #3:- Caltrans QA Inspector observed six ZPMC workers performed drilling process on exterior double plates of the skin plate A for west tower lift #3. The exterior double plates are located at tower strut connection areas. The holes template has been installed and secured by hold devices, the alignment of holes template has accepted by ZPMC and ABF prior drilling hole. Based on Caltrans QA inspector observations, no discrepancies were noted.

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## WELDING INSPECTION REPORT

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### CLOSING STATEMENT

Unless otherwise noted, all work observed on this date appeared to generally comply with applicable contract documents.

### Summary of Conversations:

As notes within report above.

### Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Skyler Guest 15000422360 , who represents the Office of Structural Materials for your project.

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<b>Inspected By:</b>	Pau,Wai	Quality Assurance Inspector
<b>Reviewed By:</b>	Clifford,William	QA Reviewer

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